

Date: Tuesday, 16/12/2008 2:12:25 PM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: ARM		
Job Number	: 44122A03					
Estimate Number	: 10145					
P.O. Number	:			Part Number	: D2037101	
This Issue	: 16/12/2008		S.O. No. :	Drawing Number	: D2037 REV D	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type :	Drawing Revision	: D	
Previous Run	: 41854			Material	:	
Written By	:			Due Date	: 22/12/2008	
Checked & Approved By	<u>JUL 08 12.16</u>			Qty:	4 Um: Each	
Comment	: Est Rev:A New Issue 05-11-01 JLM					
	Est Rev:B 08-07-29 revD as per dwg DD verified by:EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0750W049	304 RD Tube .750 x .049W



Comment: Qty.: 4.1118 f(s)/Unit Total : 16.4472 f(s)  
 Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless tubing (M304TR0.750W.049)  
 Batch: M110113

SB 09/04/07

(4)

2.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Punch as per Dwg D2037. Keep hole distance 45.50" using Jig D2037-101T1

SB 09/04/07

(4)

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill Ø0.323" holes in D2037-101 tube as per Dwg D2037

2-Flatten ends of D2037-101 tube as required using DT8545

3-Deburr as required



*m/f 09/04/28*

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 09/04/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 16/12/2008 2:12:26 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 44122A03

Part Number: D2037101

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Carl*

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*MF*  
*09-04-29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

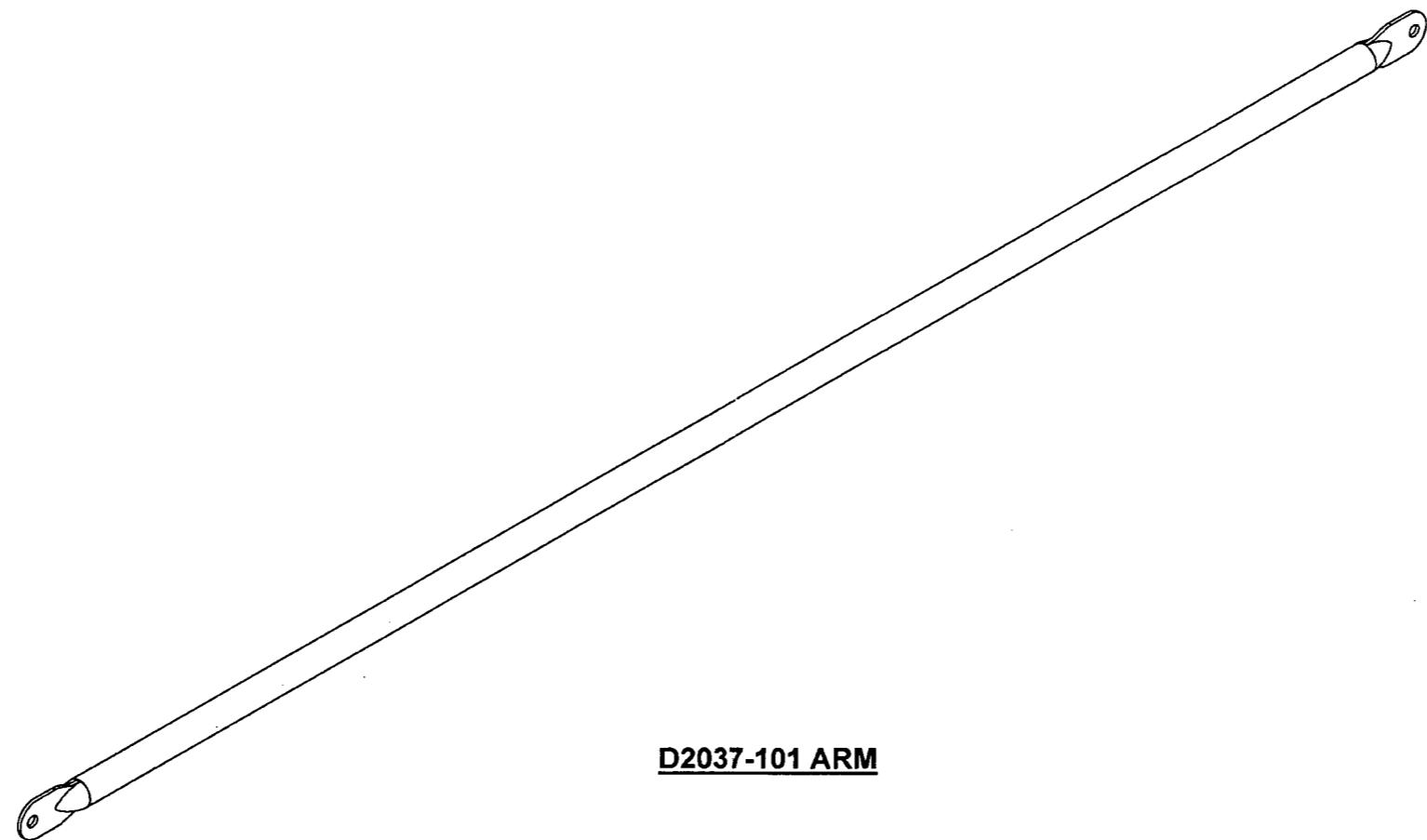
C

B

B

A

A



**D2037-101 ARM**

SHOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 4122103

RELEASER  
680707/103

**NOTES:**

- 1) MATERIAL: AISI 304/316, STAINLESS STEEL ROUND TUBE,  $\phi 0.750 \times 0.049$  WALL  
REF. DART SPEC M304TR0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.50 lbs
- 8) FOR FURTHER INFO SEE DRAWING D2638.

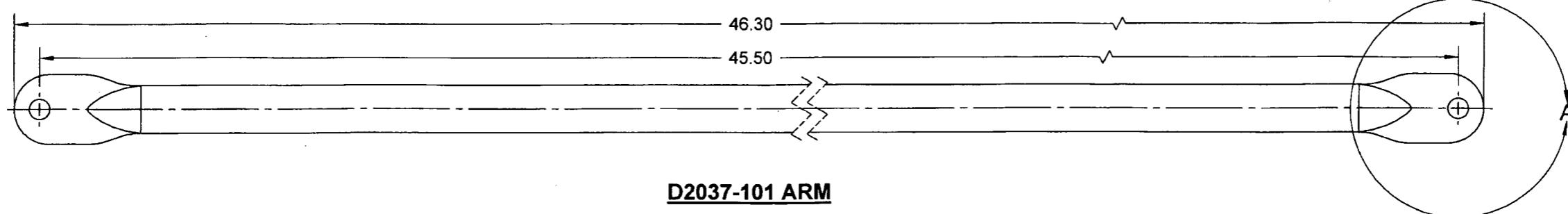
D	INCORPORATED C1,C2 & C3. REDRAWN TO SOLIDWORKS FORMAT WITH CURRENT STANDARDS. ORIGINAL "SQUARE END" CONFIGURATION DELETED (SEE REV. C FOR FURTHER DETAILS). SHEET 2 DETAIL A NOW INDICATED AS 2 PL. REASON FOR CHANGE: QC/PRODUCTION REQUEST.	AJS	08.05.08
C	REDRAWN, 0.386 WAS 0.375.	RF	99.06.07
B	-103 DELETED	JB	93.04.20
A	NEW ISSUE	JB	91.10.22
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JB	DRAWING NO.	REV. D
MFG. APPR.	JB	D2037	SHEET 1 OF 2
APPROVED	JB	TITLE	SCALE
DE APPR.	JB	ARM	NTS
DATE	08.05.08	COPYRIGHT © 1991 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

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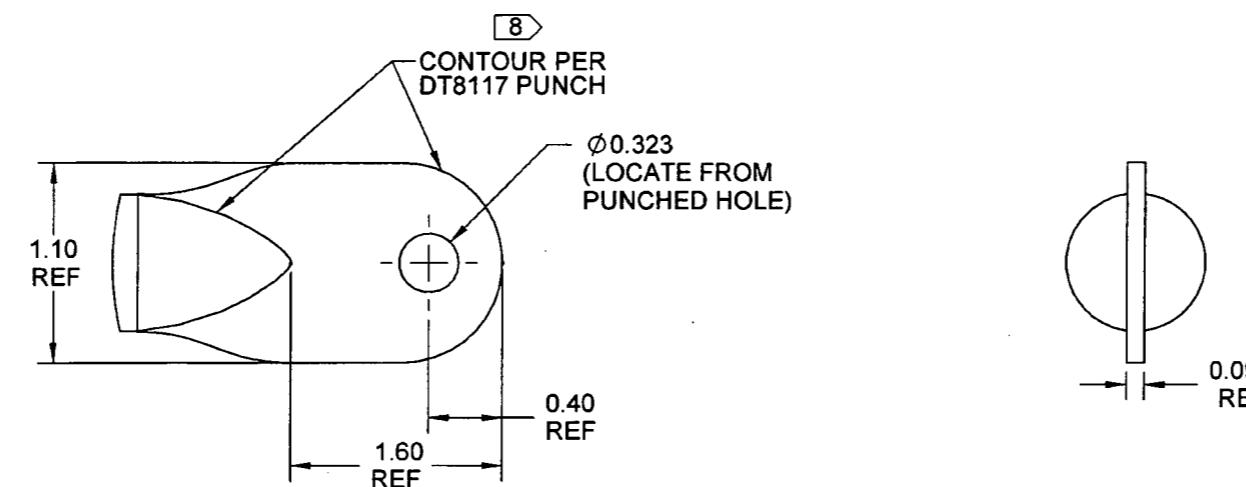
D



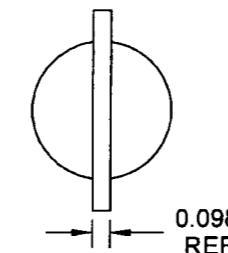
D2037-101 ARM

C

C



DETAIL A  
SCALE 2X  
2 PL



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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 441122A03

RELEASED BY [Signature]  
08-07-07  
NO. 441122A03

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2037 REV. D SHEET 2 OF 2
DRAWN	AJS	
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	08.05.08	TITLE ARM SCALE NTS
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8 7 6 5 4 3 2 1